

# Work Order ID 50516

July 13, 2009 11:34:21 AM

## PRELIMINARY ISSUE



Item ID: D2855-3

Accept



Setup Start



Revision ID: A-PRELIM

*B (Prelim)*

Stop



Item Name: Cap

*Ref 09.07.13*

Start Date: 7/13/09

Start Qty: 1.00



Cust Item ID:

Required Date: 7/14/09

Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2855

Rev A

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

PULL FROM STOCK:  
1 X D2855 B42806

-REMOVE INSERTS  
-SHORTEN I.A.W D2855 REV.B 09.06.30

*Ref 090713*

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

### ENGINEERING APPROVAL

*Ref 09.07.13*

# Work Order ID 50516

July 13, 2009 11:34:21 AM

Page 2

Item ID: D2855-3

Accept

Revision ID: A-PRELIM

Item Name: Cap

Start Date: 7/13/09 Start Qty: 1.00

Required Date: 7/14/09 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

START 2:05  
OVEN TEMP 3:20  
FINISH 3:05

09-07-13

BR

Memo

-BUFF TO REMOVE GREEN PAINT, RE-POWDER COAT WHITE PER QSI005

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

09-07-13

170



Small Fab

Small Fab

Small Fab

0.00

0.00

Memo

INSTALL INSERTS PER DWRG

M110768 09-07-13

# Work Order ID 50516



Page 3

July 13, 2009 11:34:21 AM

Item ID: D2855-3

Accept



Setup Start



Revision ID: A-PRELIM

Stop



Item Name: Cap

Start Date: 7/13/09

Start Qty: 1.00



Cust Item ID:

Required Date: 7/14/09

Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

=> 8/9/09/13 (40)



QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location Per

0.00



Packaging

Memo

0.00

09-07-13 (X)

Packaging

**ENGINEERING  
APPROVAL**

OK RA 09.07.14

200

QC21- Final Inspection - Work Order Release

0.00

09/07/16



QC

Memo

0.00

Quality Control

POSITIVE REGALL

EFFECTIVE

AUTH

RELEASED

DATE

09.07.15

# Picklist Print

Page 1

July 13, 2009 11:34:21 AM

Work Order ID: 50516

Parent Item: D2855-3RevA-PRELIM

Parent Item Name: Cap

Comments:

Start Date: 7/13/09

Required Date: 7/14/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-225		Purchased	No			100	Each	877.0000	2.0000			



INSERT

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse  
ST

877 110768

2

07-07-28

100895  
100896  
102018  
110118  
111529  
111581

21  
102  
102  
52  
300  
300

D2855RevA

Manufactured No

Each

16.0000

1.0000



Cap

Warehouse  
Location

Loc Qty

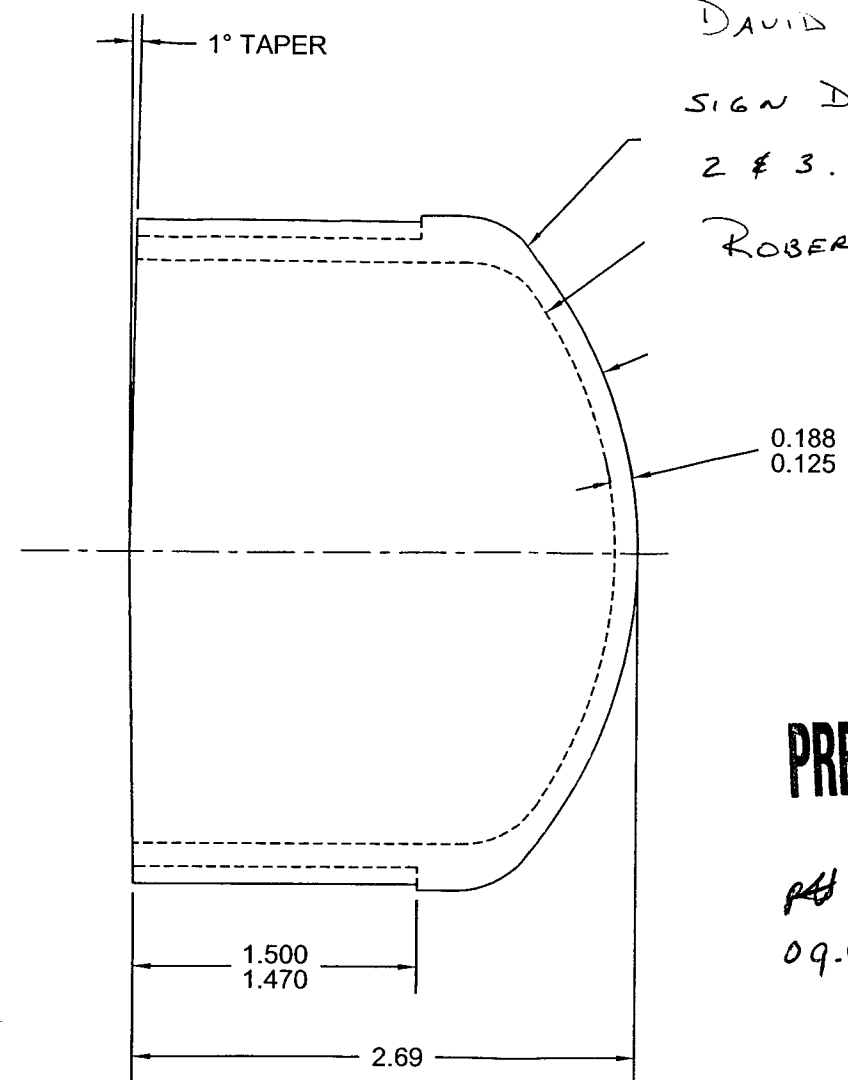
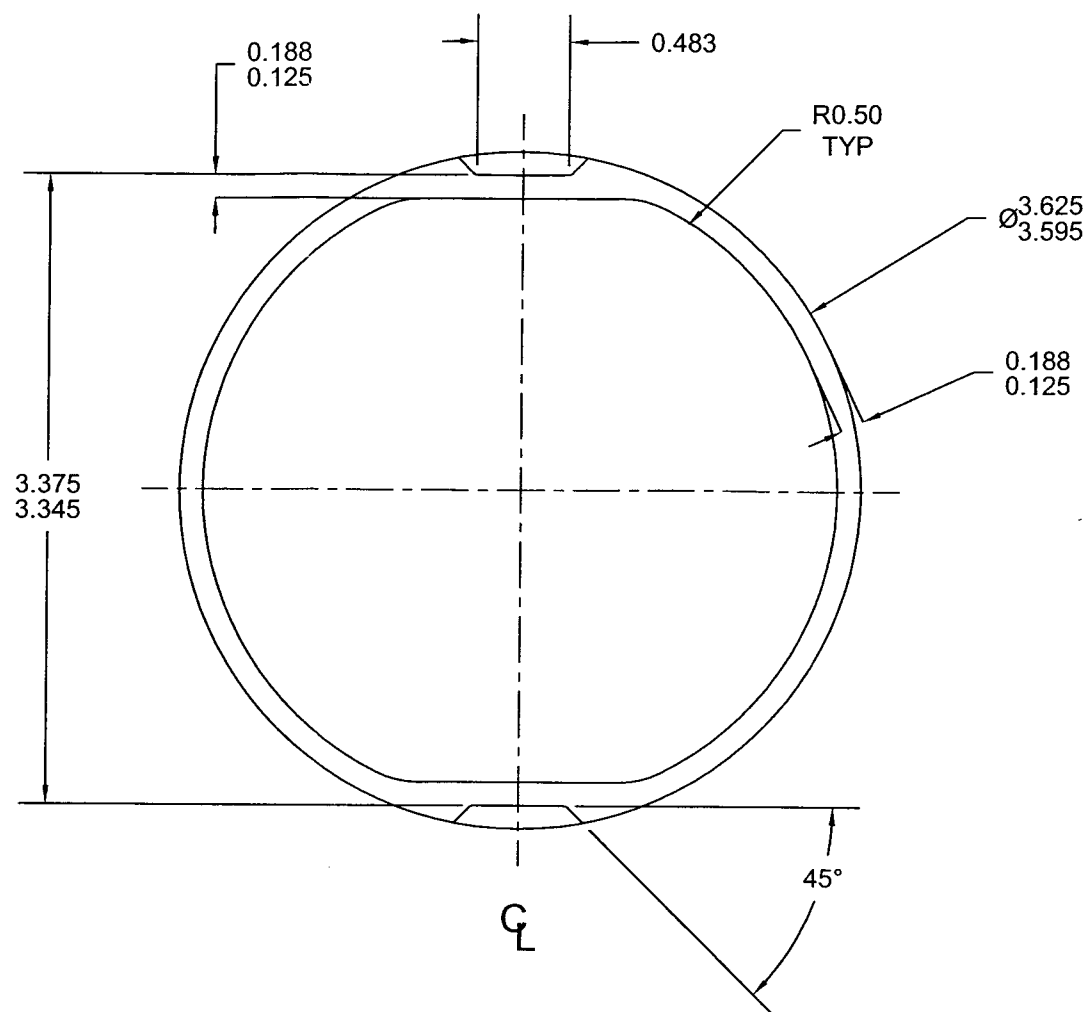
Loc Code

Main Warehouse  
ST

16  
2  
7  
1  
3  
3

10360  
35663  
41340  
42343  
42806

070713



MIKE,  
DAVID NEED TO  
SIGN D2855 SHEET  
2 & 3.  
ROBERTO

**PRELIMINARY ISSUE**

09.07.13

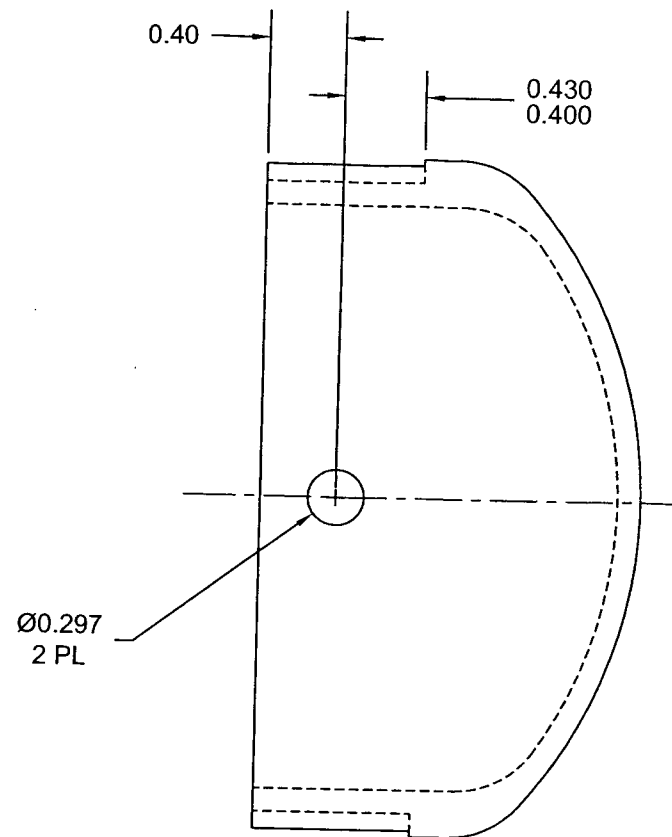
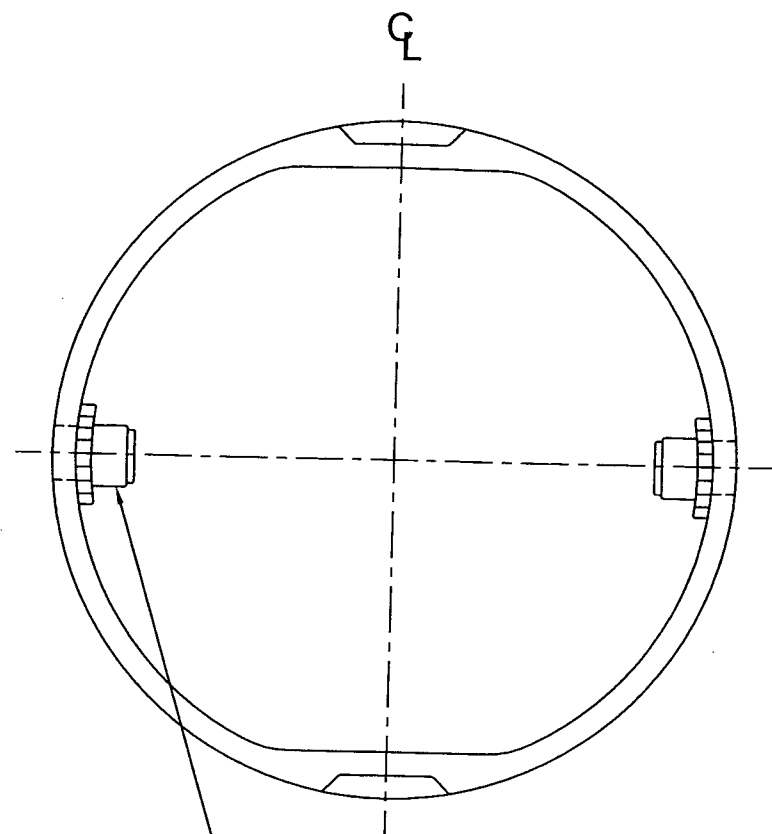
**RELEASED**

**D2855C CASTING DETAIL** B


**NOTES:**

- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)	RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)	DS	96.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. REV. B	
MFG. APPR.		D2855 SHEET 1 OF 3	
APPROVED		TITLE SCALE	
DE APPR.		CAP NTS	
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR  
ALS7-1032-225, OR AKS4-1032-225) INSERT ON  
INSIDE OF CAP (AFTER POWDER COAT)  
2 PL

**D2855-3 CAP**   
(MAKE FROM D2855C CASTING)

**NOTES:**

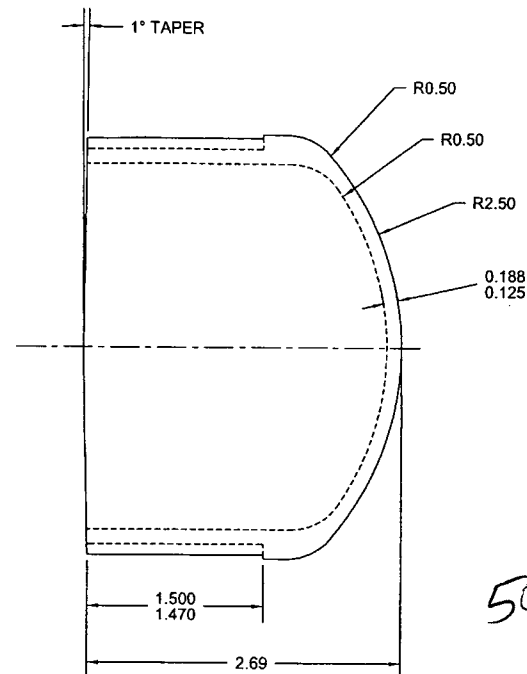
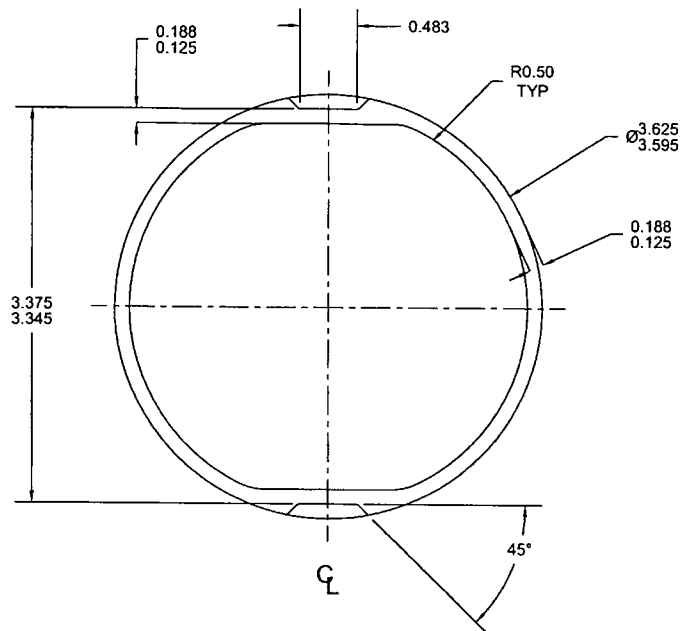
- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

**PRELIMINARY ISSUE**

*PH*  
09.07.13

**RELEASED**

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>PH</i>	DRAWING NO.	REV. B
MFG. APPR.		D2855	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CAP	NTS
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50516

# D2855C CASTING DETAIL

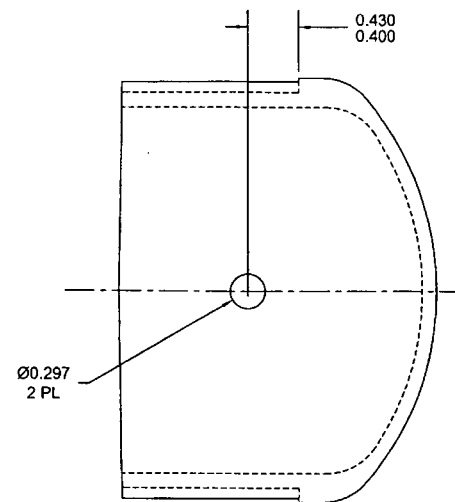
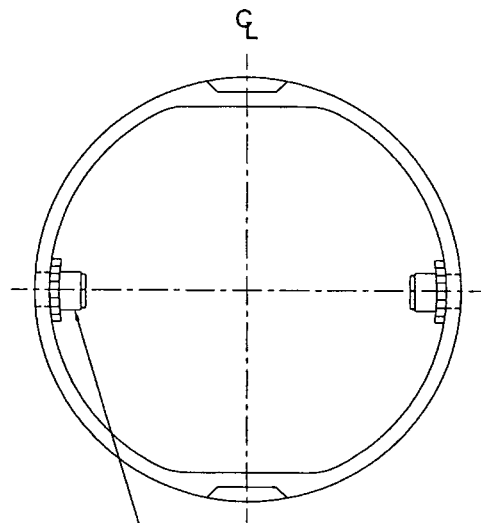


RELEASED  
09/12/15/16/17

## NOTES:

- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)	RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)	DS	96.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D2855	SHEET 1 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CAP	NTS
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INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR  
ALS7-1032-225, OR AKS4-1032-225) INSERT ON  
INSIDE OF CAP (AFTER POWDER COAT)  
2 PL

# **D2855 CAP** (MAKE FROM D2855C CASTING)

50516

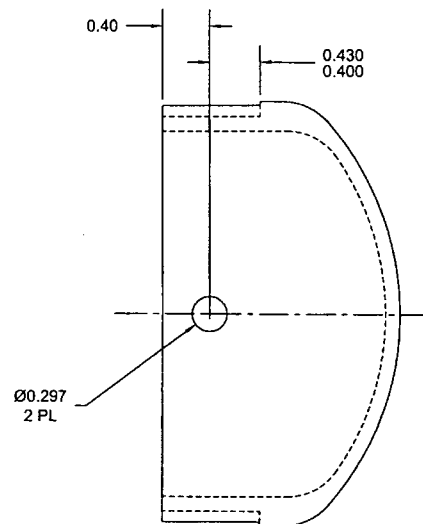
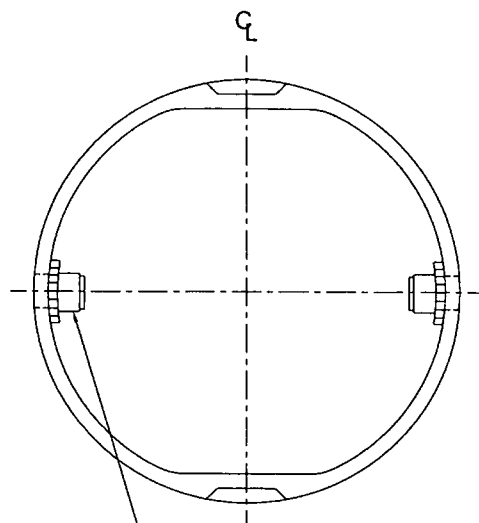
**RELEASED**  
21/12/15

## **NOTES:**


- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: PODER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D2855	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
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





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2 PL

**D2855-3 CAP**   
(MAKE FROM D2855C CASTING)

**NOTES:**

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- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2855	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CAP	NTS
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50514

**RELEASED**  
2021/5/10